

Work Order ID 57881

Monday, April 19, 2010 3:33:49 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Item Name: Aft Door Assembly

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 10/4/20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

S. 10/6/15

HJ for BG 10/06/14

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 11710
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

CL 10-4-20

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

Rec'd 4/10/10

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Inspect as per Dwg D2445.
Audit process sheet.*5/6/14**(YU)*

140



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble all of the above parts as per Dwg D350-588

BT 10-06-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

155

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

160

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control



(40)

10-6-14 SP

(40)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: 43

0.00

0.00

Memo

REUD

16-6-15

sf

12

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/06/16
10-6-15
1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 57881

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS
per DS19414 DD verified by:EC
10.03.29 verified by:EC



IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN526C832R9		Purchased	No			140	Each	418.0000	8.0000			
												
Screw											RT 10-06-14	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327 418
113845 18
114341 200
114405 200

AN960JD10 Purchased No



Washer

NAS 1149 363635

W 114292

AN960JD8 Purchased No



Washer

NAS 1149 0N8325

114740

D2143 Manufactured No



Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST198 35
37739 9
55323 26

X 8

RT 10-06-14

RT 10-06-14

RT 10-06-14

X 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS
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10.03.29 verified by:EC



IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2144	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 140	Unit of Each	Qty on 60.0000	Remaining 1.0000	Qty	Date	Status
											10-06-14	
Hinge Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST198

60

55061

8

55179

52

D2463

Manufactured No

140

f

512.5036 7.2500



Seal



10-06-14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST404

512.5036

43841

3

50075

15.7536

55561

493.75

(D2463-0870) cut (1) at 7.25"
**** per kit****

10-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2585	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 140	Unit of Each	Qty on 107.0000	Remaining 2.0000	Qty	Date	Status
Mounting Channel											RT 10-06-14	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST018 62

53798 2

55313 60

Main Warehouse

ST019 45

56524 45

D2586

Manufactured No

140

Each

85.0000

2.0000



Door Latch

357917 x 2

x2

RT 10-06-14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST204 85

55314 85

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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10.03.29 verified by:EC



IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2621		Manufactured	No			140	Each	118.0000	2.0000			
											ET 10-06-14	
Latch Plate, 350 Spacepod												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

118

46842

49

56526

69

x2

D2857-1

Manufactured No

140

Each

38.0000

1.0000



Hinge Bracket



ET 10-06-14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST026

38

55019

19

56529

19

x1

D2857-2

Manufactured No

140

Each

48.0000

1.0000



Hinge Bracket



ET 10-06-14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

48

55020

28

56530

20

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L08		Purchased	No			140	Each	667.0000	8.0000			
											10-06-14	
Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

400

114330

400

48

Main Warehouse

ST301

267

114056

67

114227

200

MS21042L3

Purchased

No

140

Each

1,131.000

2.0000



Nut

B 114523 + 2



85

10-06-14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

1131

113537

147

113644

984

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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per DS19414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-1-15		Purchased	No			140	Each	137.0000	2.0000			
Screw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST292	137	
112794	37	
114056	100	

AN526C1032R7	Purchased	No				155	Each	136.0000	2.0000			
Screw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST328	136	
113064	66	
113749	20	
114056	50	

AN526C832R8	Purchased	No				155	Each	140.0000	8.0000			
Screw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST327	140	
113595	140	

85 10-06-14

x2
10-6-14

2

10-6-14 SP @

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD10	NA51149D03632	Purchased	No			155	Each	0.0000	2.0000			
Washer												
AN960JD8	NA51149D0832R	Purchased	No			155	Each	0.0000	16.0000			
Washer												
D2150		Manufactured	No			155	Each	70.0000	2.0000			
Packer Doubler, Hinge												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST007

70

55016

16

55178

54

D2151 Manufactured No

155

Each

55.0000

2.0000



Packer Doubler, Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST007

55

51407

17

55319

38

Monday, April 19, 2010 3:33:49 PM

Shop Packet Print

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Dart Aerospace Ltd

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10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2153		Manufactured	No			155	Each	36.0000	1.0000			
											10-6-14	
Door Prop												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST272

36

48373

1

55324

35

Manufactured No

155

Each

28.0000

1.0000



10-6-14

D2154



Stud Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST007

28

44890

8

55325

20

1

W/O:		WORK ORDER CHANGES					
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10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2237		Manufactured	No			155	Each	95.0000	2.0000			
											10-6-14 SP	
Striker Plate												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST009

40

57255

40

Main Warehouse

ST010

55

55006

6

55312

49

D2461

Manufactured No

155

f

393.5000 7.2500



Neoprene "D" Seal

10-6-14 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST402

393.5

39782

6.5

55054

387

(D2461-0870) cut (1) at 7.25" 7
**** per kit****

D2589

Manufactured No

155

Each

0.0000 1.0000



Keys, Key Chain, 350 Hinge

B58194 10-6-14 SP 10

Monday, April 19, 2010 3:33:49 PM

Shop Packet Print

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Dart Aerospace Ltd

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10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2690-17		Manufactured	No			155	Each	8.0000	1.0000			



Cable



B58212 10-6-14 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

8

56567

8

D2858-1

Manufactured No

155

Each

40.0000

1.0000



Hinge Bracket



10-6-14 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

40

45798

7

55062

12

56423

21

D2858-2

Manufactured No

155

Each

32.0000

1.0000



Hinge Bracket



10-6-14 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

32

55063

11

56048

21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

Monday, April 19, 2010 3:33:49 PM

Work Order ID: 57881

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
FG-778150-550-ROL		Purchased	No			155	sf	2,302.000	1.0000			
7781 9oz Glass 50"x125yd												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST404	2302	
108932	108	
111166	419	
113905	1775	

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4	Purchased	No				155	Each	6,848.000	12.0000			
RIVET												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST316	6848	
104374	2848	
110398	4000	

MS20470AD4-5	Purchased	No				155	Each	618.0000	18.0000			
Rivet, Universal Head												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST319	618	
111916	618	

Monday, April 19, 2010 3:33:49 PM

Shop Packet Print

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:33:49 PM

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Parent Item: D350-588-041

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IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L08		Purchased	No			155	Each	667.0000	10.0000			
												
Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

400

114330

400

Main Warehouse

ST301

267

114056

67

114227

200

MS21042L3

Purchased

No

155

Each

1,131.000

4.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1131

113537

147

113644

984

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:33:49 PM

Work Order ID: 57881



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-08-11		Purchased	No			155	Each	119.0000	2.0000			



Screw



10-6-14 SP (10)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST288

50

114382

50

Main Warehouse

ST290

69

111977

19

113749

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

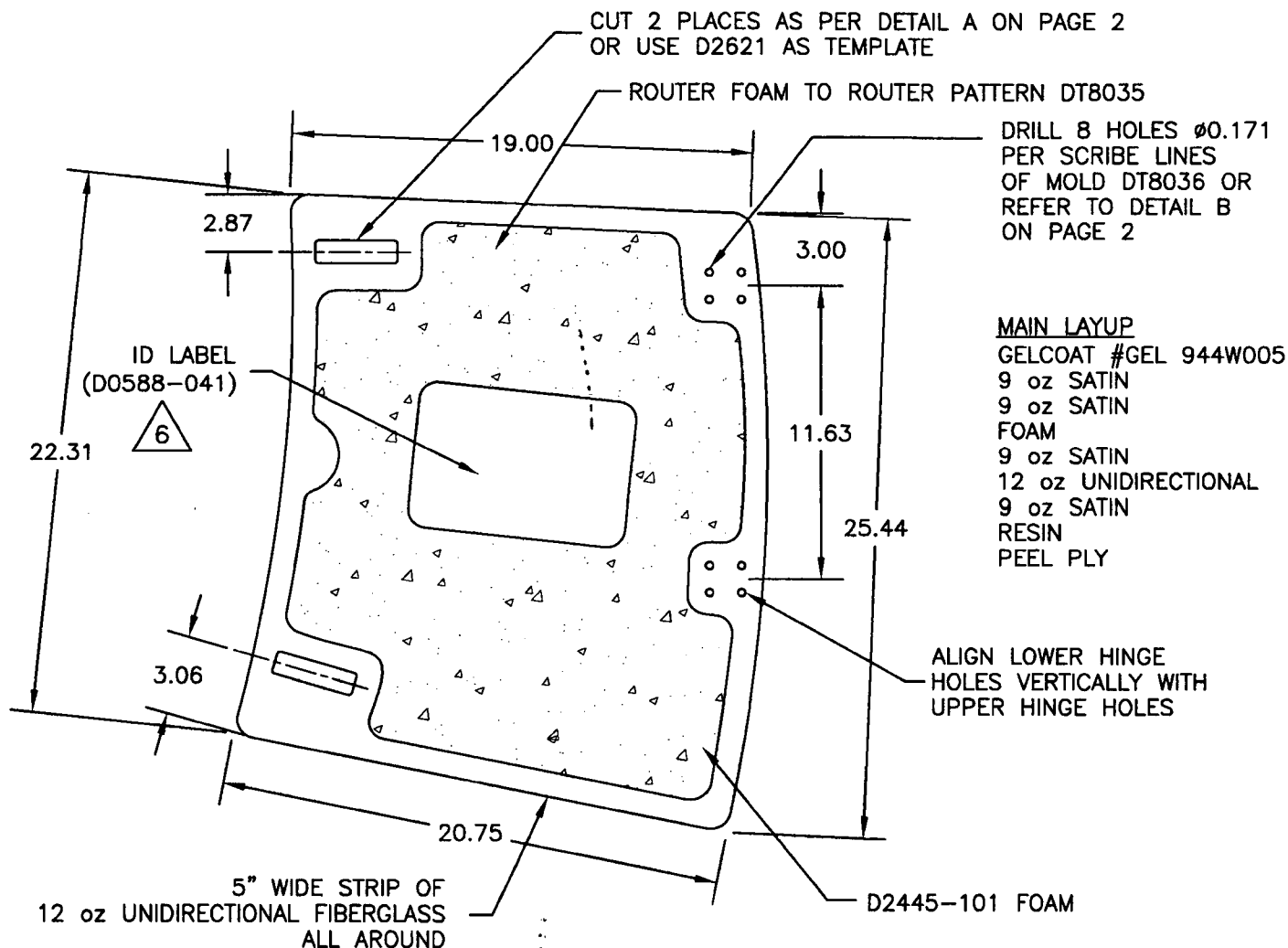
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERA KANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYLCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

C21014/20

WID: 57881

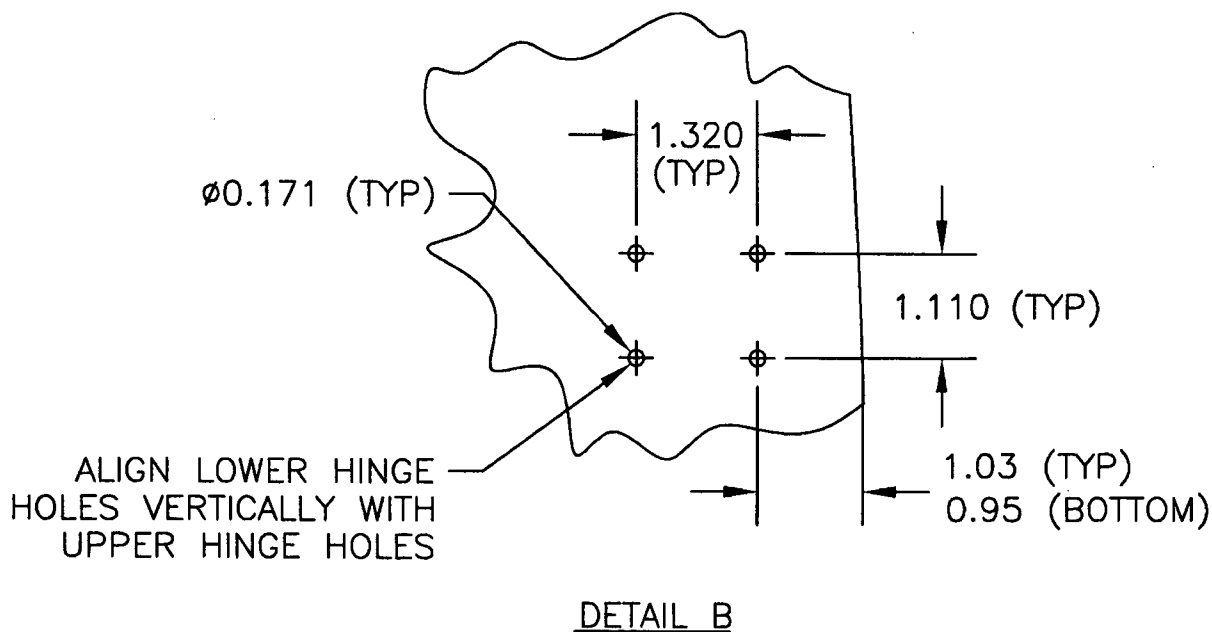
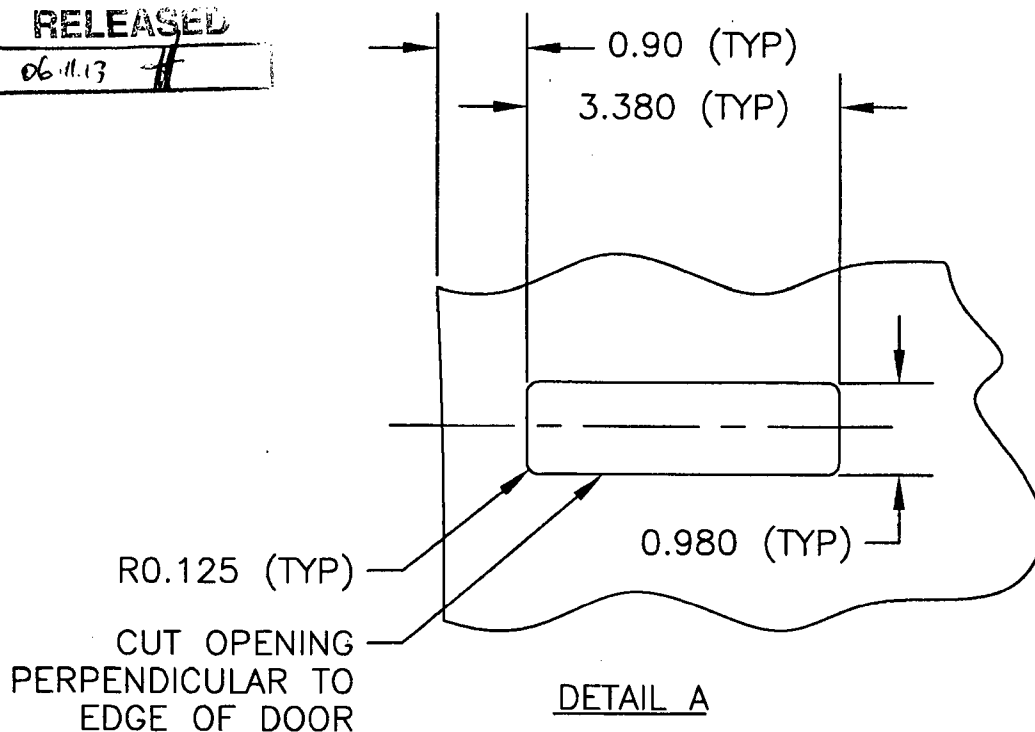
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*



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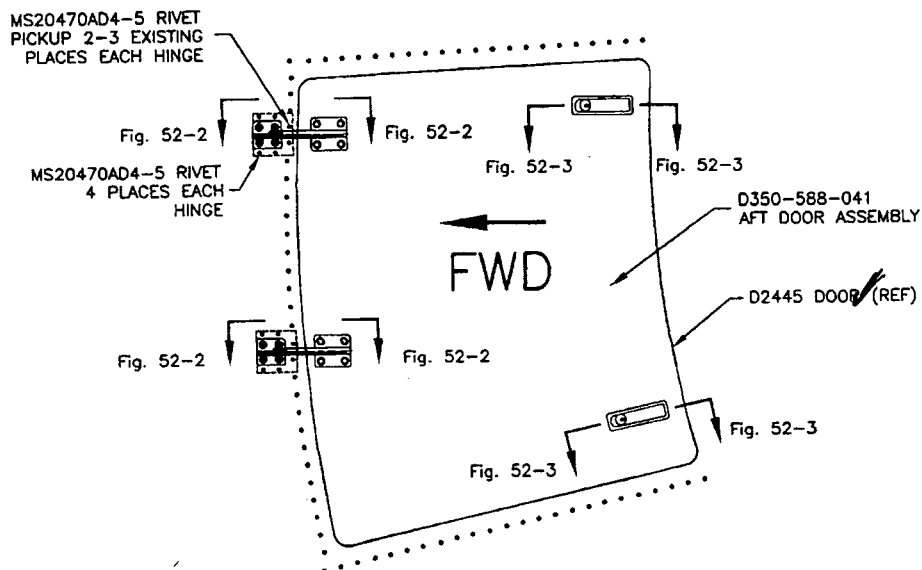


Figure 52-1: Baggage Door Outside View

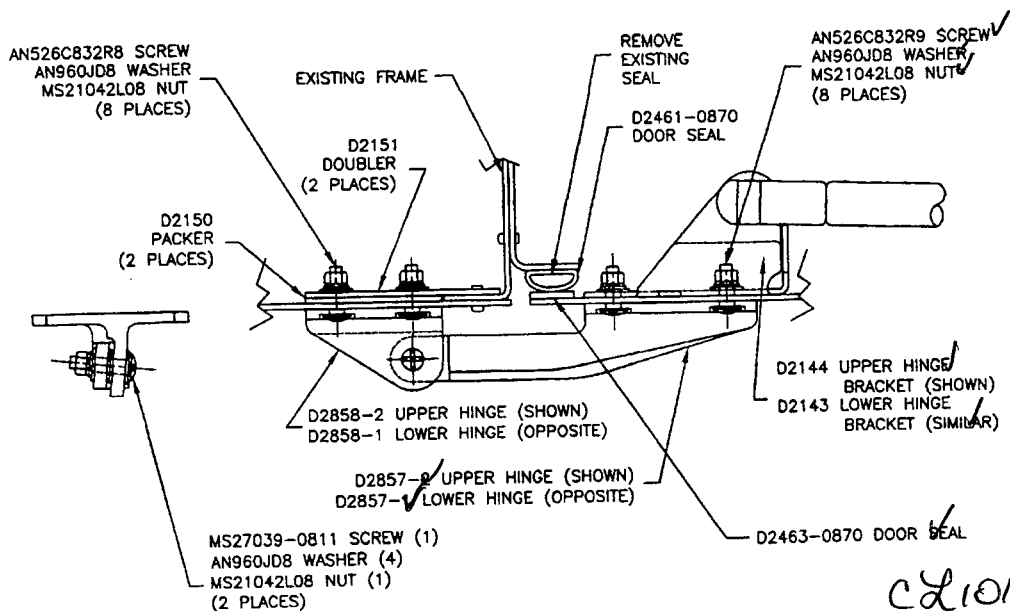


Figure 52-2: Hinge Detail

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52-00-00

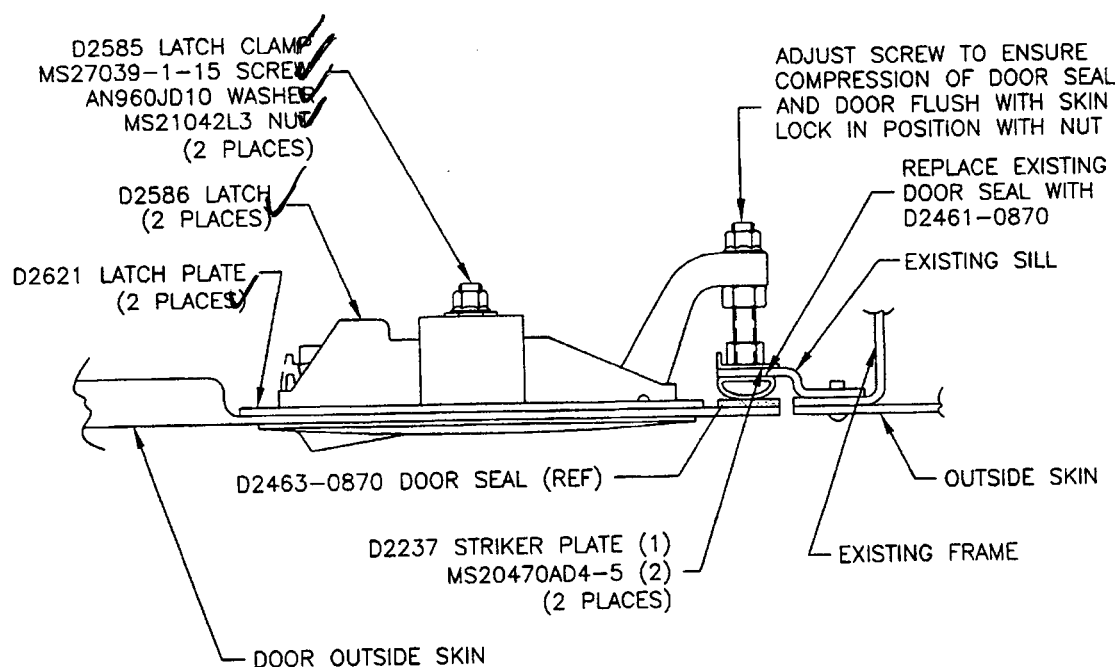


Figure 52-3: Latch Section

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52-00-00

Revision: 0

Page 5 (6 blank) of 14

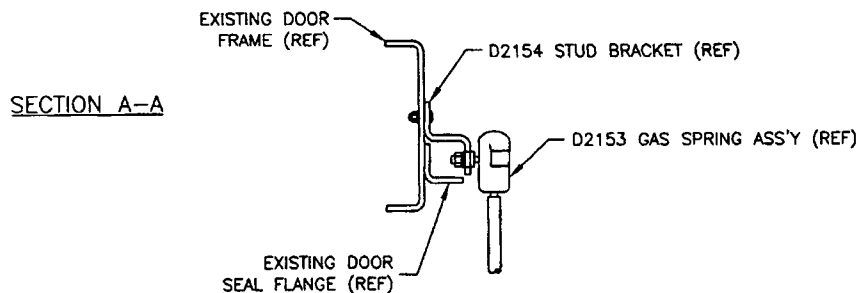
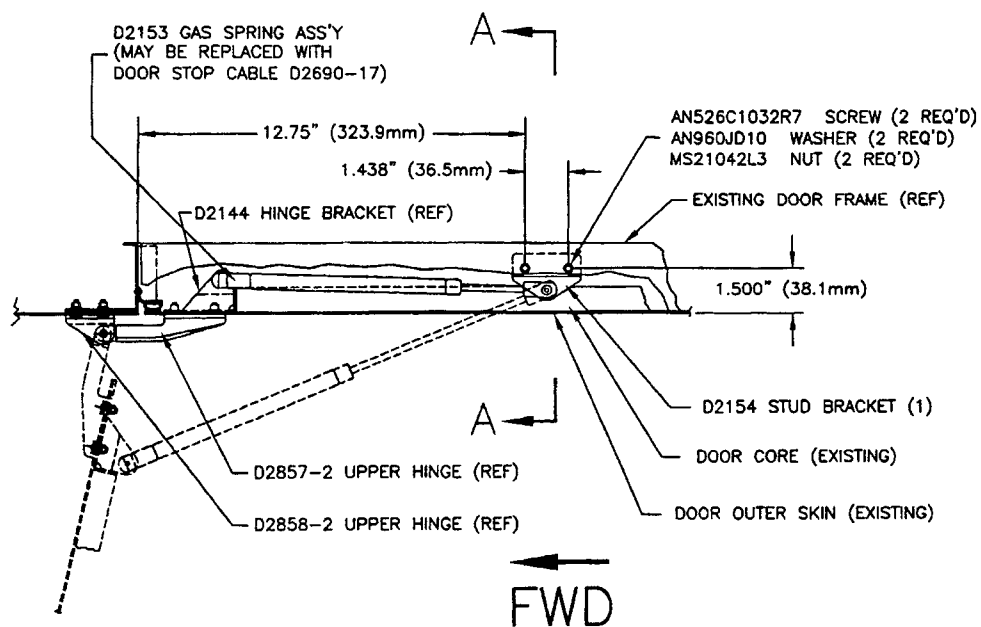


Figure 52-4: Gas Spring Installation

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Page 7 (8 blank) of 14

Revision: 0

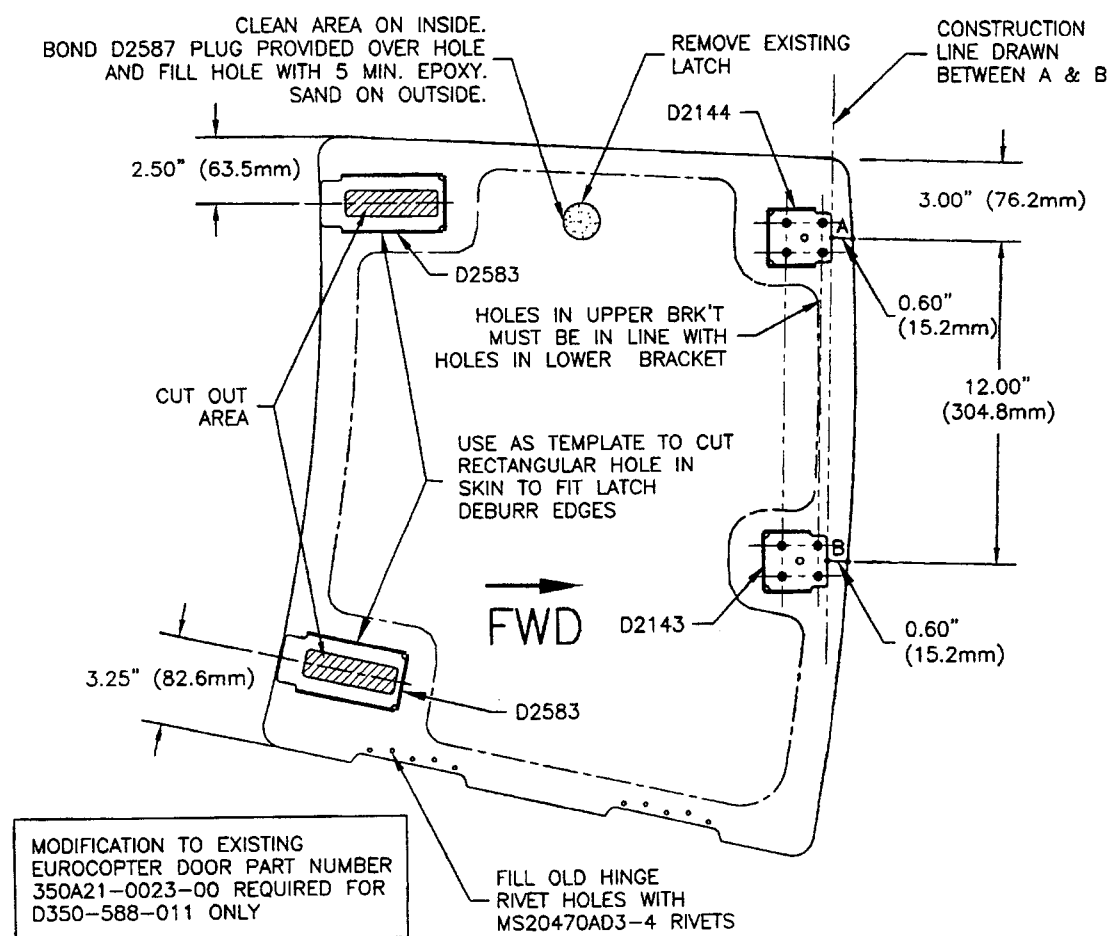


Figure 52-5: Baggage Door Inside View

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52-00-00



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice #	33395
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
10/06/2010	20/04/2010	13866	Brigitte Golden	11710			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	Line #3 D350-588-041 Aft Baggage Door (D2445) B57881 U de M : Each Drawing N° : D2445 Rév.: D <u>No. série</u> B57881 <u>No. lot</u> 25943 8 10/06/14			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Lundi, 2010-04-26 09:52:55
 Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
 Numéro Job : 25943
 Numéro Soumission : 3959
 Numéro B.A. :
 Cette fois : 2010-04-26 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : - - Type :
 Job précédente :
 Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Client: D2445

Nom Dessin : N° D2445, AFT BAGGAGE DOOR
 Numéro Article : DKC134-0013
 Numéro Dessin : D2445
 Projet Numéro : DKC134
 Révision dessin : D
 Matériel : Composite
 Date Due : 2010-05-03 Qté: 1 Udm: UNITE

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la
 Rév.: 10 de DKC

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0085	FREKOTE 3,78L 44-NC
Commentair Qty.: 0.20 UNITE(s)/Unit Total : 0.20 UNITE(s)		
2.0	PREP-GENERAL	Préparation du matériel
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire la préparation du moule N° DT-8036 selon IG 0009		
Date: 12-05-10 Heure Début: Sceau: 7		
3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)		
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-27406-1		
4.0	AMB0286	Catalyst N° DDM-9
Commentair Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)		
Catalyst N° DDM-9 N° de Lot: 1-22176-1		
5.0	AC0747	Acetone
Commentair Qty.: 0.130 KILOGRAMME(s)/Unit Total : 0.130 KILOGRAMME(s)		
6.0	PREP-GENERAL	Préparation du matériel
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire la préparation du matériel :		
Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.		
Date: 10-05- Sceau: 34 Temps Début: Temps Fin:		



Date: Lundi, 2010-04-26 09:52:55
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 25943

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 12-05-10 Sceau:  Temps Début: 7:10 Temps Fin: 

8.0	AC0883	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

9.0	AC0884	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

10.0	AC0885	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

11.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

12.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-206697-1

13.0	AMB0349	Fiberglass 12 oz Unidirectional
------	---------	---------------------------------

Commentair Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

14.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

15.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissu de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: Lundi, 2010-04-26 09:52:55
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 25943

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 30 AVRIL Heure Début: Heure Fin: Sceau: 

16.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.


Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27342-1

18.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 12-5-10 Heure Début: Heure Fin: Sceau: 

19.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 12-5-10 Heure Début: Heure Fin: Sceau:  



20.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 12-5-10 Heure Début: Heure Fin: Sceau:  

Curing début: 12:30 Curing Fin: 8:00

Date: Lundi, 2010-04-26 09:52:55

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 25943

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

21.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

22.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27342-1

23.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préapration de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 5-5-10 Heure Début: — Heure Fin: — Sceau:  

24.0 AAC1611 Polybond B46F

Commentair Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)
Polybond B46F N° de Lot: 1-7089-1

25.0 DKC134-0029 Foam Core N° D2445-101 (Pour AFT Baggage Door)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: 43653

26.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Assembler le DKC134-0029 selon IG 0033

Date: 14-5-10 Heure Début: — Heure Fin: — Sceau:  



27.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air embiant pendant 2 heures minimum.

Date: 14-5-10 Heure Début: — Heure Fin: — Sceau:  Curing Début: 12:45 Curing Fin: 4:25

Date: Lundi, 2010-04-26 09:52:55
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 25943

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

28.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

29.0 AMB0212 Résine (411B7530) 411-350 p omo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27342-1

30.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 18-5-10 Heure Début: — Heure Fin: — Sceau:  

31.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 18-5-10 Heure Début: — Heure Fin: — Sceau:  

32.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air embiant pendant 4 heures minimum.

Date: 18-5-10 Heure Début: — Heure Fin: — Sceau:  

Curing Début: 1:55 Curing Fin: 9:05

Date: Lundi, 2010-04-26 09:52:55

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 25943

Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

33.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce selon IG 0018

Date: 19-5-10 Heure Début: Heure Fin: Sceau: 

34.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 28-5-10 Heure Début: Heure Fin: Sceau: 

35.0

AAC1605

Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Label N° D0588-041

N° de Lot: 1-27282-1

36.0

AAC1609

Surface Veil

Commentair Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)

Surface Veil

N° de Lot: N/A

37.0

AAC1220

Résine Mia-Poxy 100

Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)

Résine Mia-Poxy 100

N° de Lot: 1-25679-1

38.0

AAC1221

Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)

Durcisseur 95 Pour Résine Mia-Poxy

N° de Lot: 1-25679-2

39.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le abel N° D0588-041 selon IG 0111.

Laisser scher pendant 4 heures.

Date: 3/6/10 Heure Début: Heure Fin: Sceau: 

Date: Lundi, 2010-04-26 09:52:55
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 25943

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

40.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.025 KIT(s)/Unit Total : 0.025 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-7129-1

41.0 AAC1617 Du cisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot: _____

42.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 28-5-10

Heure Début: _____

Heure Fin: _____

Sceau: _____



43.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-26575-4

44.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-26575-5

45.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer selon I.G. 0008

Quantité: 1 Date: 02/06/10 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____



1/07/06/10



Primer final

46.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 8-6-10

Heure Début: _____

Heure Fin: _____

Sceau: _____



47.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: Lundi, 2010-04-26 09:52:55
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 25943

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date 28-06-10 Sceau:

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1	1	D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
2	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
1	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
1	1	D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
2	2	MS27039-1-15	SCREW
2	2	MS27039-1-11	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries